

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021488**Date Inspected:** 01-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

The Quality Assurance (QA) Inspector, Rick Bettencourt was on site at the job site between the times noted above.

The QA Inspector was on site to randomly observe the in process welding and inspection of the weld joints identified as, 2W-pp15-W3-4, 3W-pp22-W4-2&4 following items were observed:

2W-pp15-W3-4

The QA Inspector randomly observed the ABF welder Darcel Jackson excavating a R2 repair of the above identified lifting lug hole. The QA Inspector noted the SE QC Inspector Gary Ersham had previously transferred the ultrasonic testing data from the top side of the deck to the bottom side of the deck. The QA Inspector noted the weld defect was approximately 5mm from the bottom side of the deck. The QA Inspector noted the ABF welder excavated the defect utilizing the carbon arc gouging method and ground to bright metal with a burr bit grinder. After the grinding was completed the QA Inspector randomly observed the SE QC Inspector identified above perform magnetic particle testing, the QC Inspector indicated no relevant indications were located at the time of the testing. The QA Inspector randomly observed the ABF welder Darcel Jackson preheat the isolated excavation and performed the SMAW repair utilizing 1/8" E7018 low hydrogen electrodes with 124 Amps in the 4G position. After several passes of weld material the QA Inspector noted the weld repair was complete. The ABF welder performed grinding tasks and ground the repair area flush with the base material. The QC Inspector performed VT of the completed repair and indicated the repair was acceptable.

3W-pp22-W4-2&4

The QA Inspector randomly observed the ABF welder Mike Jimenez performing carbon arc gouging and back grinding of the above identified weld joints. The QA inspector randomly observed the ABF welder grind the back

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

gouged weld joints to bright metal. The QA Inspector randomly observed the back gouged weld joints and noted they appeared to be in general compliance with the contract requirements. The QA Inspector randomly observed the SE QC Inspector Gary Ersham perform magnetic particle testing of the back gouged weld joint and noted no relevant indications were present at the time of the testing. The QA Inspector randomly observed the ABF welder continue welding the in process lift lug hole restoration of the lifting lug hole identified as #2. The QA Inspector noted the weld joint was approximately 60% complete at the time of the SMAW 4G back weld. The QA Inspector randomly observed the ABF welder continue the SMAW cover pass. The QA Inspector noted the ABF welder completed #2 and moved over to #4. The QA Inspector randomly observed the SMAW parameters were 1/8" E7018 low hydrogen electrodes with 119 Amps. The QA Inspector noted the parameters appeared to be in general compliance with ABF-WPS-1070A R1. The QA Inspector randomly observed the ABF welder did complete the above identified lifting lug hole on this date. The QA Inspector noted the weld reinforcement was ground flush on the QA Inspectors shift. The QA Inspector observed the grinding did appear to comply with the contract requirements for the lifting lug hole identified as #2 & #4.

The QA Inspector spent the remainder of the shift at Anamet Testing Hayward Ca witnessing fillet weld soundness test macro etch specimens. See TL-6032 for today's date for additional information.

Summary of Conversations:

No pertinent conversation noted.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Bettencourt,Rick	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
